Work Orde November-21-13				*100				Page 1				
tem ID: Revision ID:	D2161-205			Accept	*N900	040	100	7* s	etup Sta	I VI -	S1*	
tem Name:	Mirror Bracke	et, 205							Sto	$^{\mathrm{op}}$ *N:	S2*	
Start Date:	11/21/13	Start Qty: 2.00	*2*		Cust Item ID:							
Required Date:	11/21/13	Req'd Qty: 2.00	*2*		Customer:					_		
Reference:							_	R	tun S#	ift and a	D4*	
Approvals:	Process Pla	an: MLJ	Date: 13-11-22	_ Tooling:	D)ate:			Ste	"N	K 1 "	
	QC:		Date:	_ SPC (Y/N):	Date:				50	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	vision Nbr										
D2161	Rev	/ B2										
100				0.00								
100 Large Fab		Large Fab Memo		0.00				(2)		206	13.11-2	
Large Fab		2-Weld as j	e on Jig DT8065 as per Dwg per Dwg D2161 Identify as . rod: m/25	D2161-205								
110		QC9- Inspect visual per	r QSI004- Fusion Welds	0.00								
110 QC		Memo		0.00				2	<u>B</u>	-11.29	DAS 9-89	
Quality Control												
120		QC5- Inspect part comp	pleteness to step on W/O	0.00							DAS 9	
120				0.00				2	_13	26-11-	9-89	
OC		Memo		0.00								

Memo

Quality Control

												DQA:	Da	te:		
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE																
,											(QA Closed:	Da	te:		
Work Orde	sř.					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Work Orde	- ' -					Rework	1		Skid-tube	Crosstube	Water Jet				Engineering	
Part No.						Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor.		Quality	
101010						Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other	
NCR No.						Work Order Update]		Large Fab	Composite			Supplier			
			1	,	T			<u> </u>			_					
Root			l		1	ption of work order update	l .	Initial		tion	1	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	ription	1	Date	Verificatio	n	QC Inspector	
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Equip/Tooling						٠.	Ì									
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Supplier			1		1	•										
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				•	•	F	AUI	LT CATE	GORY							
Landi	ng (ear				General										
Bending						Bend		Grain			٦	Ovalized			Pressure/Forced	
	Г	Centre N	ot Conce	ntric to	o/s	BOM/Route	\vdash	Hardwa	ire		٦	Over/Under	tolerance		Temperature/Cure	
	Г	Cracks				Broken/Damaged		Inspect	ion Incomplete		-	Part Incorrec			Weld	
	Crushed/Crimped Burrs							1	ions Incomplete/	/Unclear	٦,	Part Lost/Missing			Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 109623 Page 2 *109623* November-21-13 2:44:11 PM Accept Item ID: D2161-205 *N900040100* Setup Start **Revision ID:** Stop Mirror Bracket, 205 Item Name: Start Qty: 2.00 11/21/13 **Cust Item ID: Start Date:** Req'd Qty: 2.00 Required Date: 11/21/13 **Customer:** Reference: Start Run Process Plan: Date: Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: QC: Reject Reject Insp. Operation Set Up/ **Tool ID** Tool # Plan Accept Sequence ID/ Stamp Qty Qty Number Code Work Center ID Description **Run Hours** Black Sandtex(Ref 4.3.5.7) per QSI005 4.3 0.00 130 9-89 *130* 0.00 Powdercoat **Powder Coating** DAS 0.00 QC3- Inspect Part Finish 140 *140* QC Memo Quality Control Identify as per dwg & Stock Location: 150 0.00 PPP 109869 *150* Packaging Memo

Packaging

												DQA:	Da	te:		
NCR:	⁄es	/ No				WORK ORDER NON-	100	VFOR	MANCE / UP	DATE		•				
		·				#			•			QA Closed:	Da	te:		
Work Orde	or.					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Work order.						Rework	1		Skid-tube Crosstube			Water Jet			Engineering	
Part N	۱o.					Scrap	1		Machining	Small Fab	_	Prod	d. Eng. Coor.	-	Quality	
	•					Use-as-is	1		noforming	Finishing	Rec/Store/Packaging			-	Other	
NCR 1	۷o.					Work Order Update	1 1		Large Fab	Composite			Supplier	-		
	·								· · · · · · · · · · · · · · · · · · ·							
Root					Descri	ption of work order update		nitial	i	tion	1	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector	
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		Bending				Bend		Grain			ي ا	Ovalized			Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		(Over/Under	tolerance		Temperature/Cure	
		Cracks				Broken/Damaged		Inspect	ion Incomplete	Γ	F	Part Incorrec	t		Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination Countersink

Cut Too Short

Drill Holes

Drawing Finish

Folio

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Work Orde				*109				Page 3			
Revision ID:	D2161-205 Mirror Bracke	t, 205		Accept	*N900	040	100)* s	Setup Sta		NS1* NS2*
Start Date: Required Date: Reference:	11/21/13 11/21/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:						·
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ıte:		F	Run Sta	**	NR1*
	QC:		Date:	SPC (Y/N):	Date:				Sto	^{op} *	NR2*
Sequence ID/ Work Center II 160 *160* QC Quality Control)	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	7//	Reject Num M 13	ber Stamp

NCR: Y	es / No				WORK ORDER NON-C	ONF	ORN	MANCE / UPI	DATE						
	·									QA Closed:	Date	:			
Work Orde	r:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
					Rework	Skid-tube Crosstube					Water Jet	Engineering			
Part No.					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality			
					Use-as-is	Т		noforming	Finishing	Rec/Stor	re/Packaging	Other			
NCR N	lo				Work Order Update			Large Fab	Composite	ļ	Supplier				
Do	1	**-	Г	Docorio	ntion of work and an undata	Initi	-1	A at	tion	Cian 0	<u> </u>	1			
Root	Date	Ston	Otal	·	otion of work order update or Non-conformance	Chief		1	ription	Sign & Date	Verification	QC Inspector			
Cause Doc/Data	Date	Step	Qty		or Non-comormance	Cillei	CHE	Descr	приоп	Date	verification	QC Inspector			
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Operator															
Material	-														
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Supplier															
Training															
Unapproved															
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Landir	ng Gear				General					_					
	Bending				Bend	Gr	ain			Ovalized		Pressure/Forced			
	Centre No	ot Conce	ntric to C	D/S	BOM/Route	Ha	rdwa	ire		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged		-	ion Incomplete		Part Incorred	 	Weld			
	Crushed/	Crimped			Burrs	\vdash		tions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs				Contamination	_		enance		Part Moved					
	Heat Trea			_	Countersink	—	slabe		<u> </u>	Positioned V		7			
	Inspectio		Tube	_	Cut Too Short	\vdash	isread	d		Power Loss/	Surge	Other			
	Ripples in			<u> </u>	Drill Holes	\mathbf{H}	fset								
	Torque W			<u>ا</u>	Drawing	Out of Calibration									
	Turning S	l	Finish	Ot	it of S	Sequence									

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

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Work Order ID:

109623

Parent Item:

D2161-205

Parent Item Name:

Mirror Bracket, 205

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP Rev:A New	Issue 05-11-01	JLM									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Issued Issu	
D2013-1 / Mirror Bracket LH, 205		Manufactured	No			100	Each	2.0000	1	2^{j^2}	me	13.11.28
				Location		Loc Qty	<u>Lo</u>	c Code				
				WA001		2			-			
				107	387	2			_×6	۷		
Mirror Bracket RH, 205		Manufactured	No			100	Each	2.0000	1	<u>گار 2</u>	208	13.11.28
				Location		Loc Oty	<u>Lo</u>	c Code				
·				WA001 <u>4:0</u> 73	325	2 2			*6	2		
D2037-101 Arm		Manufactured	No			100	Each	5.0000	1	آ (ع) ع	me	<u>13-11</u> .28
				Location		Loc Oty	<u>L</u> c	oc Code				
				WA001		5						
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QA:		Date:	

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WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Dat	e:
Work Orde	ř •				DISPOSITION	İ			AGAINST DE	PARTMENT	PROCESS	
Part N	o				Rework Scrap Use-as-is Work Order Update	Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging						Engineering Quality Other
Root	<u> </u>	T		Descri	ption of work order update	Initi	ial	Ac	tion	Sign &	<u>,</u>	<u> </u>
Cause	Date	Step	Qty		or Non-conformance	Chief	i		ription	Date	Verification	QC Inspector
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rocess							İ					
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	Bending				Bend	Gr	ain			Ovalized	l	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	На	rdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pecti	on incomplete		Part Incorred	it [Weld
	Crushed/	'Crimped			Burrs	Ins	tructi	ons Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			L	Contamination	Шм	ainte	nance		Part Moved		
ļ	Heat Trea	at			Countersink	Мі	slabe	led	L	Positioned V	Vrong	
	Inspectio	n Strip in	Tube	L	Cut Too Short	Мі	sread			Power Loss/	Surge	Other
Į	Ripples in	n Bend			Drill Holes	Of	fset					
	Torque V	Vaves in I	Extrusio	n _	Drawing	∐o _u	it of C	alibration				
	Turning S	Sequence	!	Ĺ	Finish		it of S	equence				
	Wave/Tv	vist in Tul	be		Folio	Ou	ıtside	Dimensions				